

Work Order ID 110497

December-23-13 9:51:34 AM

110497

Rev A 8/13/12/24
~~2011 CANADA ISSUE~~
~~2011 MINNAPOLI ISSUE~~

Page 1

Item ID: D5021-5

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Foam

Stop

NS2

Start Date: 12/23/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DAS 27 10
9-89 9-89

D5021

pa2 Rev A

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PA2

Prog Rev: PA3

2-Deburr if necessary

1 EL 13-12-23

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

1 B 13/12/23

Work Order ID 110497

December-23-13 9:51:34 AM

110497

Page 2

Item ID: D5021-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Foam
Start Date: 12/23/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/23/13 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 27 9-89 13/12/13							Inspect on per Dun PAD
140 *140* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00							Sh 13/12/13
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

DAS
27
9-89
Release Dwg 110497-23
Rev A 11/3/12/23
POSITIVE RECALL
EFFECTIVE 13/12/23 AUTH
DATE 13/12/24

Picklist Print

December-23-13 9:51:34 AM

Page 1

Work Order ID: 110497

Parent Item: D5021-5

Parent Item Name: Foam

Start Date: 12/23/13

Required Date: 12/23/13

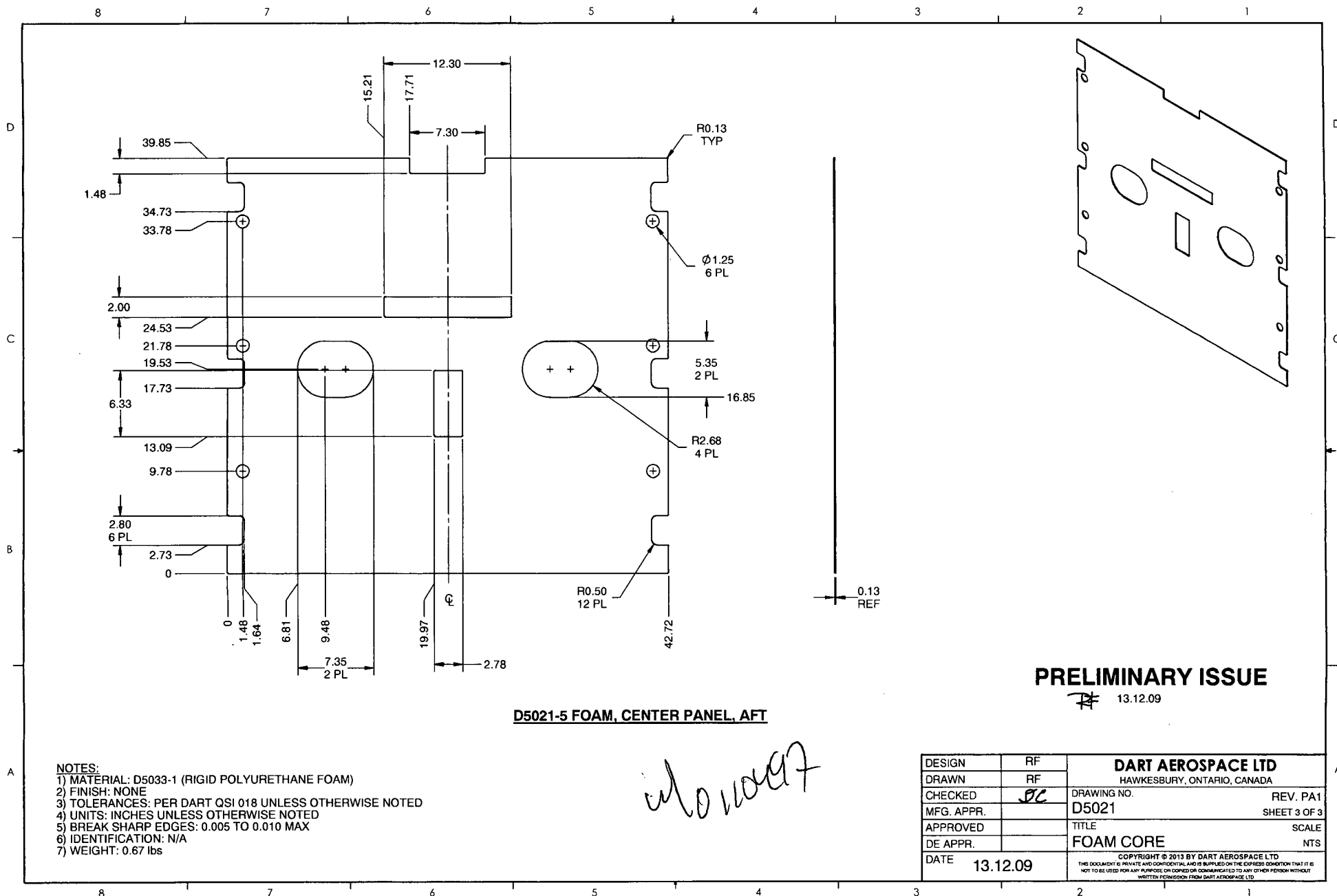
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5033-1 Rigid Polyurethane Foam		Manufactured	No				sf	0.0000		16		13-12-23	

B/110 489 x 16 59 14



DART AEROSPACE LTD		Work Order: B110497
Description: foam CENTER PANEL A-5		Part Number: DSO21-3
Inspection Dwg: DSO21	Rev: PA	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.85	+/- 0.030	39.85	✓		T	Jkm-06
42.72	+/- 0.030	42.72	✓		T	"
2.73	+/- 0.030	2.73	✓		T	Jkm-05
17.73	+/- 0.030	17.75	✓		T	Jkm-06
34.73	+/- 0.030	34.73	✓		T	"
2.80	+/- 0.030	2.80	✓		T	"
5.35	+/- 0.030	5.35	✓		T	"
7.35	+/- 0.030	7.35	✓		T	"
6.33	+/- 0.030	6.33	✓		T	"
2.78	+/- 0.030	2.76	✓		T	"
7.30	+/- 0.030	7.30	✓		T	"
2.00	+/- 0.030	2.00	✓		T	"
1.48	+/- 0.030	1.50	✓		T	"
12.30	+/- 0.030	12.30	✓		T	"
9.78	+/- 0.030	9.80	✓		T	"
21.78	+/- 0.030	21.75	✓		T	"
33.78	+/- 0.030	33.78	✓		T	"
1.25	+/- 0.030	1.25	✓		T	Jkm-05
0.130	+/- 0.030	1.50	✓		T	Jkm-05

Measured by: <u>B</u>	DAS 27 9-89	Audited by: _____	Preliminary Approval: <u>B</u>
Date: <u>13/12/23</u>		Date: _____	Date: _____

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

